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15329

D119-646-041
Job Sheet 193236



Part No: D119-646-041

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Wearpads - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15329

Due Date: 6/20/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3887-041 REV E SHEETS 1,2,5,7,8,10,11 IPP RevA: New issue DD verified by:EC IPP rev B 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/20/19	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		6/20/19	0.00	0.25	Skidtubes-1		
120	HandFinish	1 pcs		6/20/19	0.00	0.83	HandFinish1		
121	QC	1 pcs		6/20/19	0.00	0.00	QC7-1		
122	QC	1 pcs		6/20/19	0.00	0.00	QC5		
130	Skidtubes	1 pcs		6/20/19	0.00	1.54	Skidtubes-1		
135	QC	1 pcs		6/20/19	0.00	0.00	QC5		
140	Skidtubes	1 pcs		6/20/19	0.00	1.47	Skidtubes-1		
150	QC	1 pcs		6/20/19	0.00	0.00	QC5		
160	Skidtubes	1 pcs		6/20/19	0.00	1.61	Skidtubes-1		
170	QC	1 pcs		6/20/19	0.00	0.00	QC5		
180	QC	1 pcs		6/20/19	0.00	0.00	QC10		
190	HandFinish	1 pcs		6/20/19	0.00	0.83	HandFinish2		
200	Powdercoat	1 pcs		6/20/19	0.00	0.22	Powdercoat1		
210	QC	1 pcs		6/20/19	0.00	0.00	QC3		
220	HandFinish	1 pcs		6/20/19	0.00	3.83	HandFinish4		
240	HandFinish	1 pcs		6/20/19	0.00	2.00	HandFinish4		
245	QC	1 pcs		6/20/19	0.00	0.00	QC5		
255	DC	1 pcs		6/20/19	0.00	0.00	DC		
260	Packaging	1 pcs		6/20/19	0.00	0.00	Packaging3-1		
270	QC21-FG	1 Ea		6/20/19	0.00	0.00	QC21		

Part Op 110 - 1- Inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R

140 - 1- Bend FWD end of tube using bender 1 and FOLIO 31 bend prog. D3887. ***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887. ***Verify measurment*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Drill holes for wearpads using DT8931, open to 0.297". 11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 12- Deburr and blow out chips from inside of tube.

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3887. 4- Deburr & Scribe batch # on Aft end of tube.

170 - TEST FIT USING FIXTURE DT10091.

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

220 - 1-Install Inserts as per Dwg D3887.

240 - 1-Install Inserts as per Dwg D3887. 2-Install wearpads, gaskets as per Dwg D3887. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 3-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 4 -Inspect for foreign objects as per QSI 024 5 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 6 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 7- Wing Walk as per dwg and QSI Batch: _____

255 - Photocopy bluefile & type labels per PPP D119-646-041 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1' Beam Tube 4"	1 pcs (1 ea)	90-Start up Operation	
D3885-1	Standard Web	1 pcs (1 ea)	130-Skidtubes	
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes	
D2855-5	Cap	1 pcs (1 ea)	160-Skidtubes	
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes	
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes	
ALS4-1032-130	Rivnut	33 Ea (33 ea)	240-HandFinish	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-HandFinish	
AN3C4A	Bolt	6 Ea (6 ea)	240-HandFinish	
AN3C5A	Bolt	26 Ea (26 ea)	240-HandFinish	
D2855-3	Cap	1 pcs (1 ea)	240-HandFinish	
D3492-5	Plug	24 pcs (24 ea)	240-HandFinish	
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-HandFinish	
D3847-1	Wearpad	5 Ea (5 ea)	240-HandFinish	
D3847-11	Wearpad	1 Ea (1 ea)	240-HandFinish	
MS24694-C52	Screw	2 Ea (2 ea)	240-HandFinish	
NAS1149C0332R	Washer	32 Ea (32 ea)	240-HandFinish	
NAS1611-005	O-Ring	24 Ea (24 ea)	240-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	125	0
130-Skidtubes	D3885-1	1	9	0
140-Skidtubes	D2579	2	109	0
160-Skidtubes	D2855-5	1	51	0
	D3681-1	12	156	0
	D3903-1	12	103	0
240-HandFinish	ALS4-1032-130	33	8,859	0
	ALS4-1032-225	1	1,284	0
	AN3C4A	6	1,618	0
	AN3C5A	26	1,310	0
	D2855-3	1	32	0
	D3492-5	24	58	0
	D3672-1	2	1,863	0
	D3847-1	5	52	0
	D3847-11	1	15	0
	MS24694-C52	2	82	0
	NAS1149C0332R	32	4,191	0
	NAS1611-005	24	301	0

Part Specifications

Specifications could not be found.